

Date: Tuesday, 28/04/2009 2:22:30 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/212/130 BASKET LID  
 Job Number : 47573A  
 Estimate Number : 10193  
 P.O. Number :  
 This Issue : 28/04/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D2512  
 Drawing Number : D2512 REVE  
 Project Number :  
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : E  
 Material :  
 Previous Run : 47572A Due Date : 05/05/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JLD 09.04.28  
 Comment : Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/  
 RF  
 Est Rev:N 06.04.05 Added level21 EC  
 Est Rev:O 08-08-29 revE as per dwg DD verified by:EC  
 Est Rev:P 08-09-24 plug holes prior to powder coating DD  
 verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)  
 Pick:  
 3/4"x3/4" 304/316 SS tube .065" wall  
 Batch: M111331

31"inch ~~ENDISAR~~ SCRAP  
 at end pedes SCRAP

84 09/04/29

2.0 D31663 Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:  
 Qty Part Number Description Batch  
 1 D3166-3 Basket Hoop B 46629 → 1x

84 09/04/29

3.0 D2506 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:  
 Qty Part Number Description Batch  
 1 D2506 Label Plate B44205

PD 09.05.06

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Drawing Name: 350/212/130 BASKET LID

Job Number: 47573A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D23271

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2327-1 Bushing

Batch

B46325

PD 09-04-30

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2232-1 Hinge plate

Batch

B46709

PD 09-04-30

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2581 Mounting Bracket

Batch

B46086

PD 09-04-30

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description  
18 sf M304EX0.75-16F Expanded Metal

Batch

M1111 73 (4)

M111444 (W)

SAD 09-09-20 (1)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Dt9436

PD 09-05-06

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Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-05-07

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/05/07 (X)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M111472  
Pressure wash

um D/B.R.

09/05/08

1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating

2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

8:20

OVEN TEMPERATURE:

260°

FINISH TIME:

8:50

2ND COAT:

START TIME:

9:15

OVEN TEMPERATURE:

260°

FINISH TIME:

9:45

um D/B.R.

(X1)  
09/05/08

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

M111301

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M111013 BR09-05-11

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-11

(X1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PM 47523

09/05/11 (X1)

Date: Tuesday, 28/04/2009 2:22:30 PM  
User: Linda Lacelle

## Process Sheet

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Drawing Name: 350/212/130 BASKET LID

Job Number: 47573A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

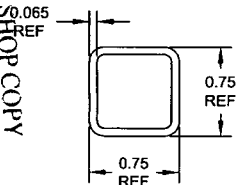
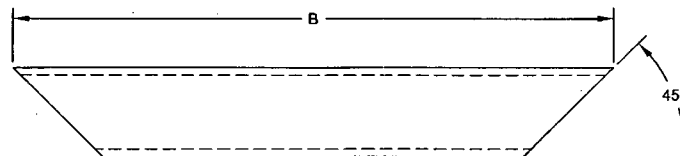
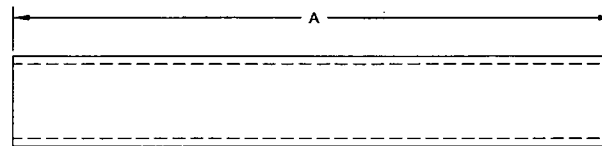
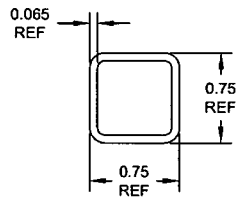
Job Completion



U 09.05.12

# **PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



**RELEASED**  
08-08-21-11

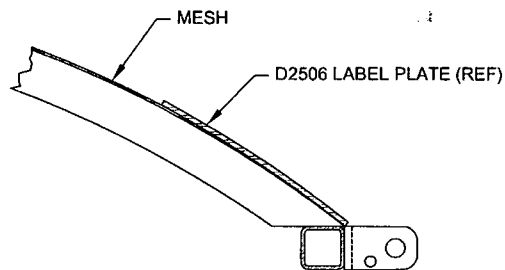
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.080 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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## **D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

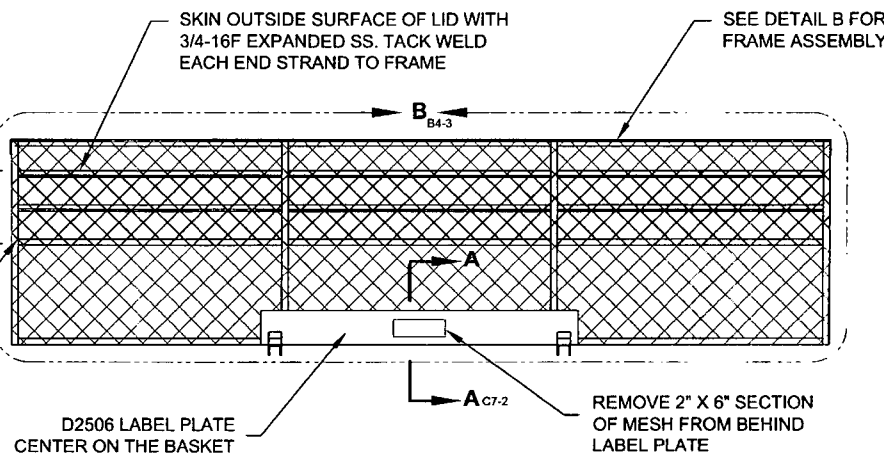
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**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



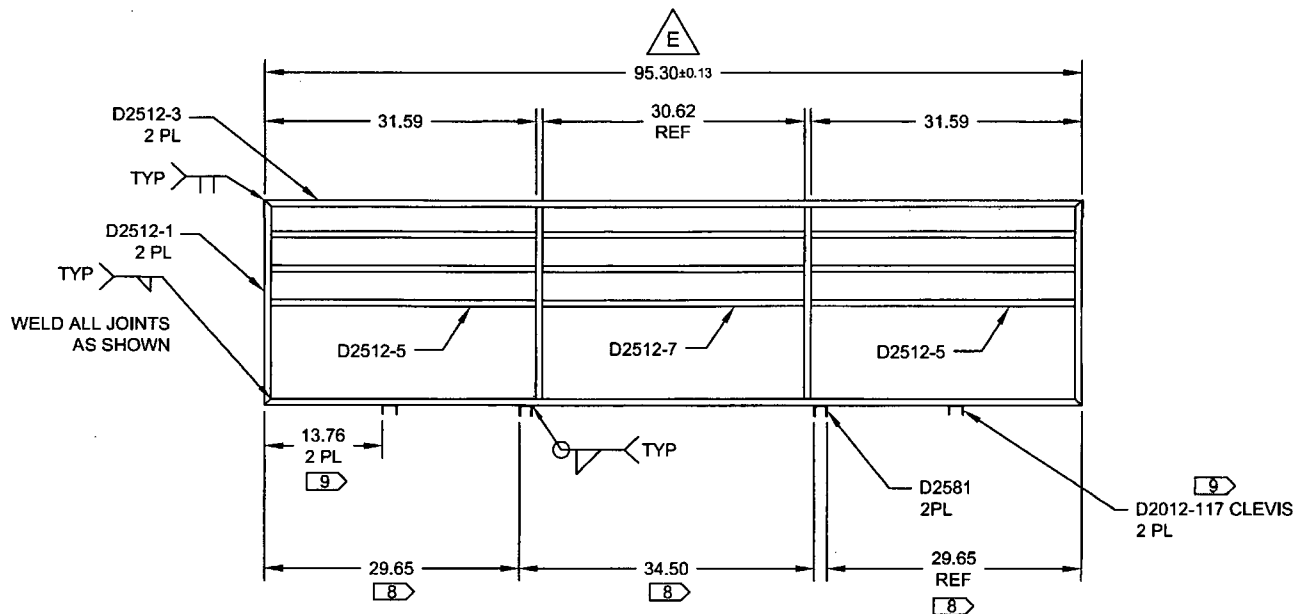
**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

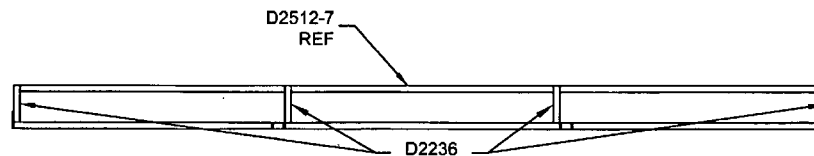
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MFG. APPR.		D2512	SHEET 2 OF 4
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**DETAIL B** <sub>C3-2</sub>  
FRAMEWORK ONLY SHOWN FOR CLARITY



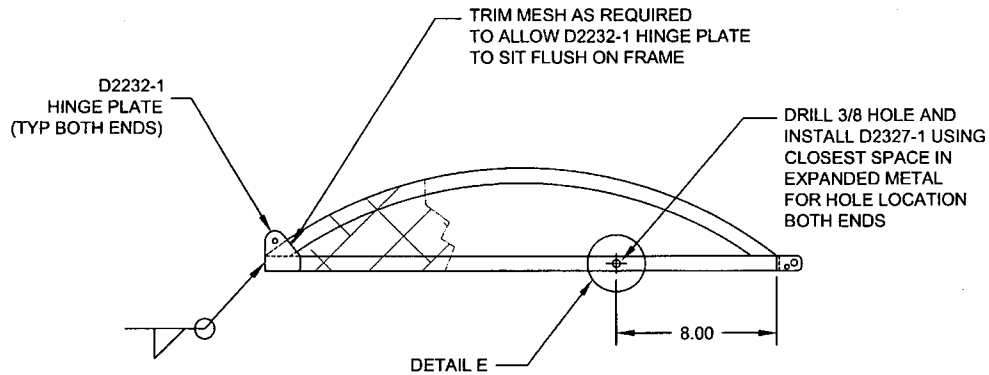
**RELEASED**  
08 06 17

- NOTES:**
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A
  - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
  - 9) FOR D130-701-041 ONLY

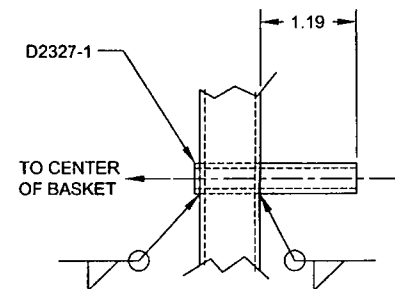
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CHECKED	J	DRAWING NO.	REV. E
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APPROVED	10	TITLE	SCALE
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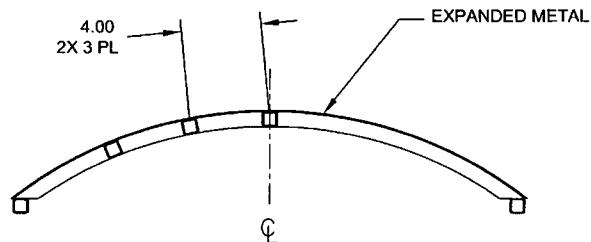
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2







**DETAIL E** C6-4



**SECTION D-D SAME BOTH CENTER RIBS** A4-2

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MFG. APPR.		D2512	SHEET 4 OF 4
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DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1